

Work Order ID 156756

Wednesday, February 08, 2017 9:09:10 AM

156756

Page 1

Item ID: 647.0112

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut Bracket

Start Date: 1/20/2017 Start Qty: 15.00

15

Cust Item ID:

Required Date: 2/10/2017 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: DAS 21 9-89 Date: FEB 08 2017

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.0100

A

100

0.01

100

FLOW WATER JET

Waterjet

Memo

0.07

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: ★

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

(18)cc 17/02/11(18)cc 17/02/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Page 2

Quality Control

18

18

18

FEB 13 2017

17-2-14

FEB 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

156756

Wednesday, February 08, 2017 9:09:10 AM

N900040100

Setup Start *NS1*

Stop *NS2*

15

Cust Item ID:

15

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

150

0.00

150

Memo

0.02

SprayPaint

PRIME AS PER DWG NOTE 6

Spray Painting

BATCH: 136615

160

QC14- Inspect Spray Paint

0.00

160

Memo

0.02

QC

Quality Control

FFR 21 2017

170

Identify as per dwg & Stock Location CCK101A

0.00

170

Memo

0.02

Packaging

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	☐ OTHER : _____					
Misidentified ☐	☐ Past Due						

Work Order ID 156756

Wednesday, February 08, 2017 9:09:10 AM

156756

Page 4

Item ID: 647.0112 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Bracket
Start Date: 1/20/2017 Start Qty: 15.00 ***15*** Cust Item ID:
Required Date: 2/10/2017 Req'd Qty: 15.00 ***15*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.25							
Quality Control									

17/2/23 JH
MF
17-2-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, February 08, 2017 9:09:09 AM

Page 1
f

Work Order ID: 156756

156756

Parent Item: 647.0112

647 0112

Parent Item Name: Strut Bracket

Start Date: 1/20/2017

Required Date: 2/10/2017

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	24.2900	0.0325	0.513158			

M304S14GA

304SS sheet .080

02/17/02/11

Location

Loc Qty

Loc Code

MAT019

24.29

M134604

4.6

M135860

1.39

M136463

18.3

.60

DQA: _____ Date: _____

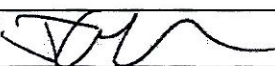
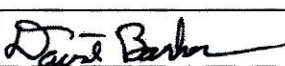
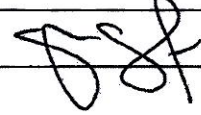


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03985				SHEET 1 OF 2	
	DWG NO. 647.0100	REV: A	PREPARED BY J. BECKER	DATE: 7/15/13		EFFECT ON DWG ☐ INC. ☒ UNINC.
	DWG TITLE: SHEET METAL					
	APPROVED BY:	ENGR. 	MFG 	QC 	EFF. NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REVISED NOTE 2. ADDED 647.0117				

IS

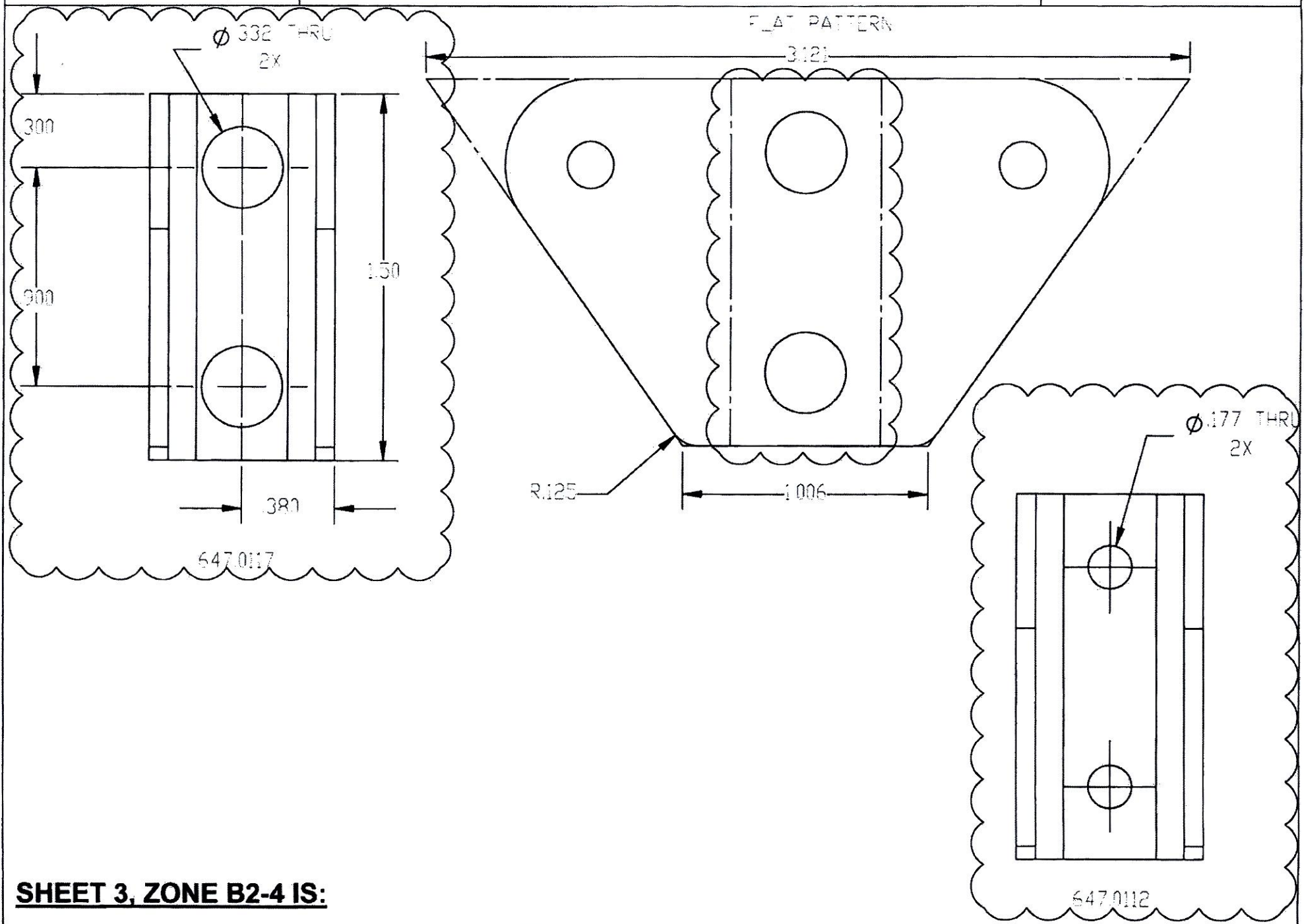
NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1,
PRETREATMENT IAW SECTION 3.1
AND PRIMER IAW SECTION 4.1.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.
- 7 OTHER DIMENSIONS SAME AS 647.0112.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 156756 M.C.S.
 17-02-08

SHEET 1, ZONE D1 IS:

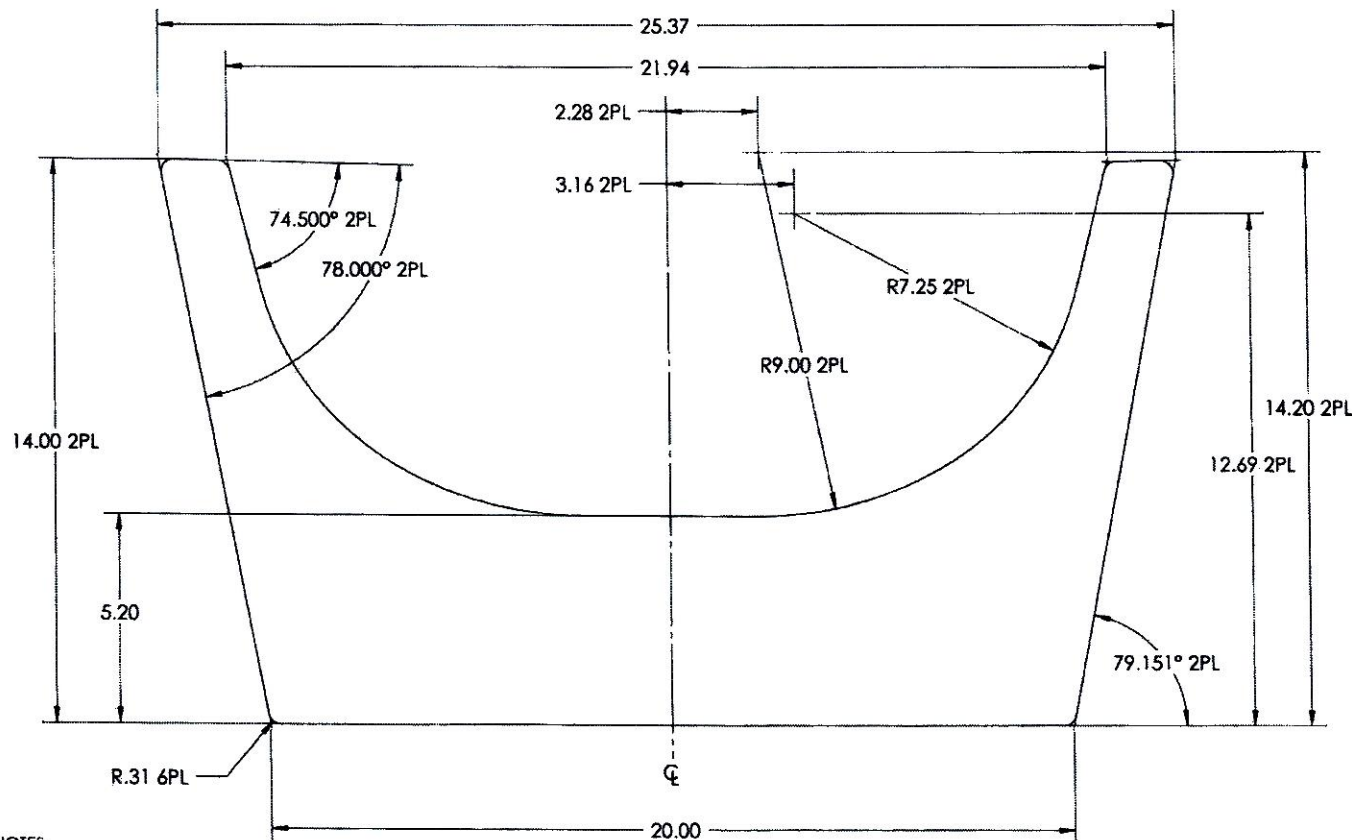
C	647.0117		STRUT BRACKET	△	△
F/NTC	PART NUMBER		DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:			CHANGE CATEGORY	DER REVIEW REQUIRED	
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM			☐ MAJOR ☒ MINOR	☐ YES ☒ NO	



SHEET 3, ZONE B2-4 IS:

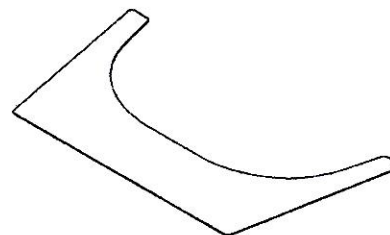
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REV	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION #12		N/C
2	TRIAL RELEASE	02/26/07	P. BRAVO
3	INCORPORATED ECN 62777 02/24/08	04/26/11	P. BRAVO



NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377 J TYPE I CLASS N.
- 3 DEBURR AND BREAK ALL SHARP EDGES.
- 4 IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377 J TYPE I CLASS N.



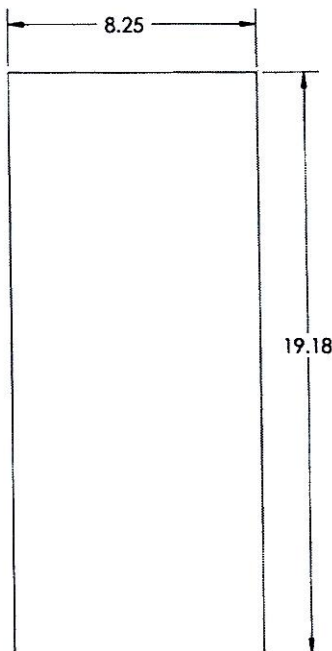
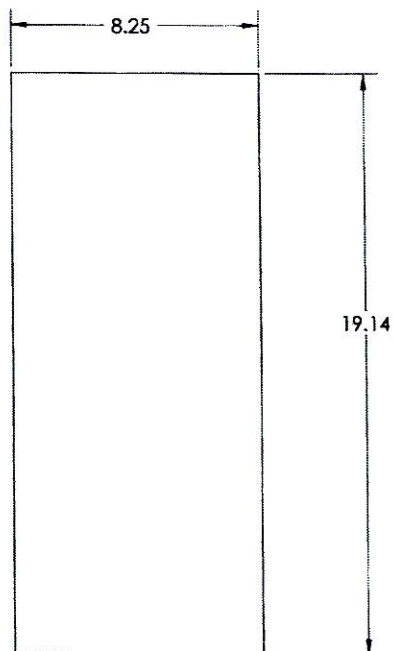
647.0110

UNINCORPORATED ECN(S)

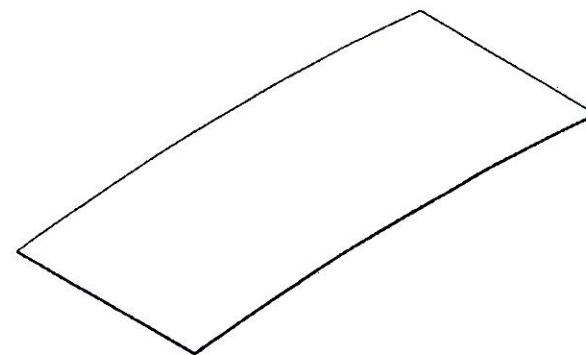
03.985

QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
		647.0116	DOUBLER	△	△
		647.0115	CLIP	△	△
		647.0114	CLIP	△	△
		647.0113	STRUT DOUBLER	△	△
		647.0112	STRUT BRACKET	△	△
		647.0111	PANEL	△	△
		647.0110	ROOF DOUBLER	△	△
PARTS LIST			APICAL INDUSTRIES		
NEXT ASSY (S)			2608 TEMPLE HEIGHTS DR.		
646.9500			OCEANSIDE, CA. 92056-3512 (760) 724-5300		
			SHEETMETAL		
			UNLESS OTHERWISE SPECIFIED		
			DIMENSIONS ARE IN INCHES		
			TOLERANCES ARE:		
			3 PLACE DECIMALS ± .01		
			ANGLES ± .5°		
			SCALE NONE		
			SHEET 1 OF 6		

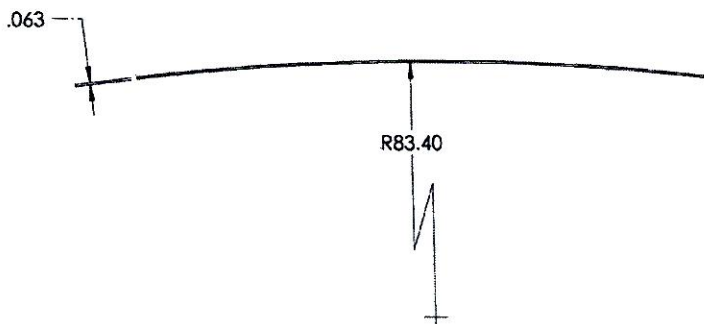
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FLAT PATTERN



647.0111

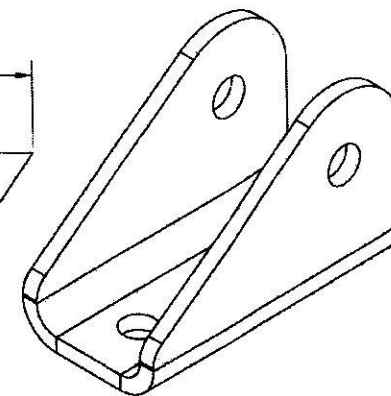
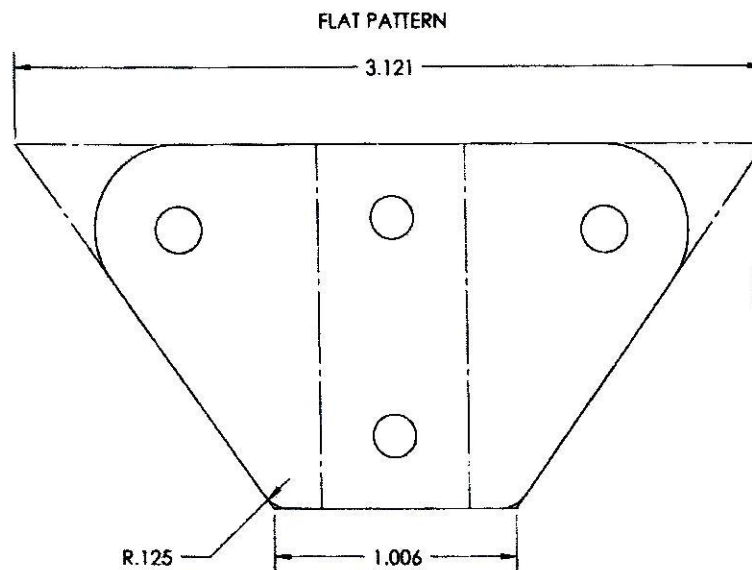
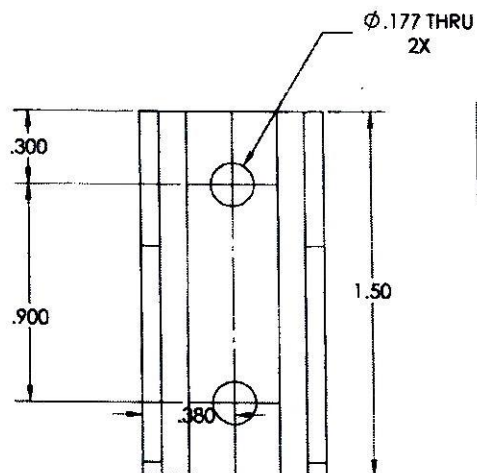


ORIGINAL DATE 11/03/84		APICAL INDUSTRIES	
DRAWN BY R. ROSANO		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL P. BRAVO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ANGLES ± .5°		SHEET 8	REV A
SCALE: NONE		SHEET 2 OF 6	

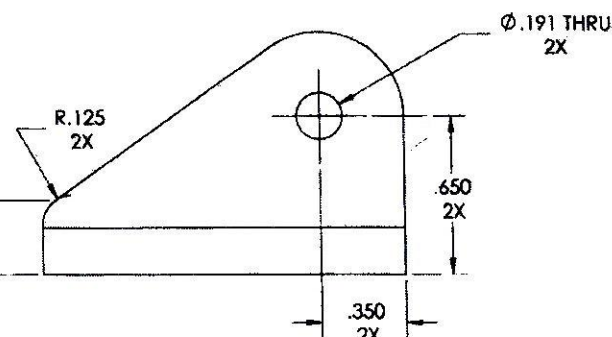
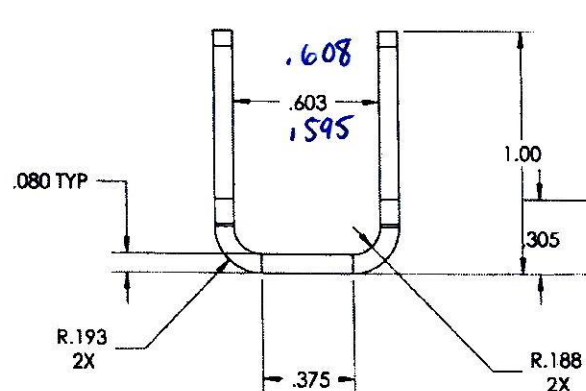
1
2
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8

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REV.	DESCRIPTION	DATE	APPROVED



647.0112



ORIGINAL DATE
DESIGNED BY
DRAWN BY
CHECKED BY
APPROVED BY
DATE

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

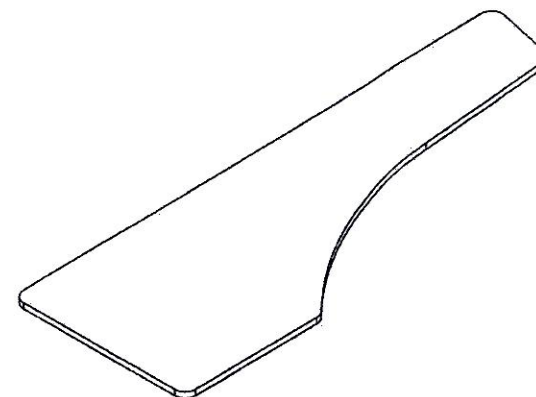
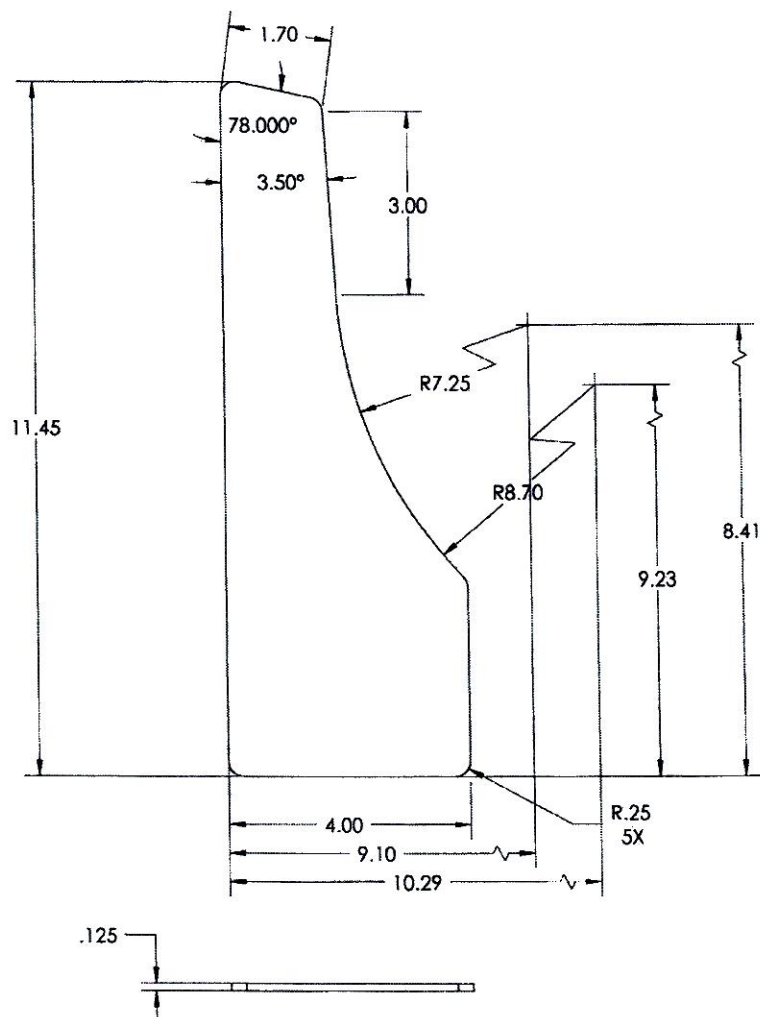
SHEETMETAL

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

SER.	AGE CODE	DWG. NO.	REV.
B	07/02/06	647.0100	A
SCALE: NONE			SHEET 3 OF 6

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

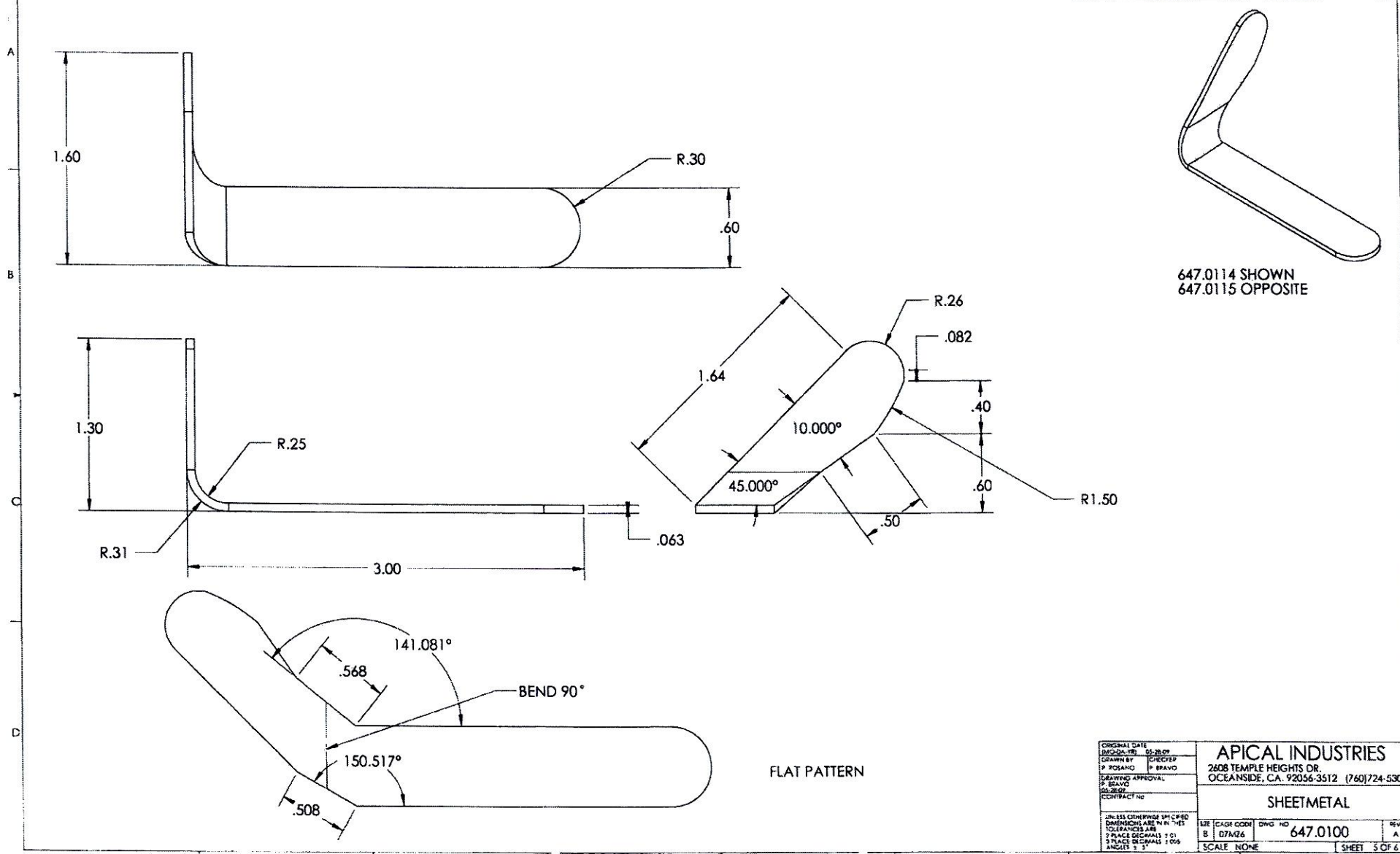


647.0113

ORIGINAL DATE: 05-28-09		APICAL INDUSTRIES	
DRAWN BY: P. ROSANO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. BRAVO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL: P. BRAVO		SHEETMETAL	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ANGLES ± .5°		REV: 647.010J	REV: A
SCALE: NONE		SHEET 4 OF 6	

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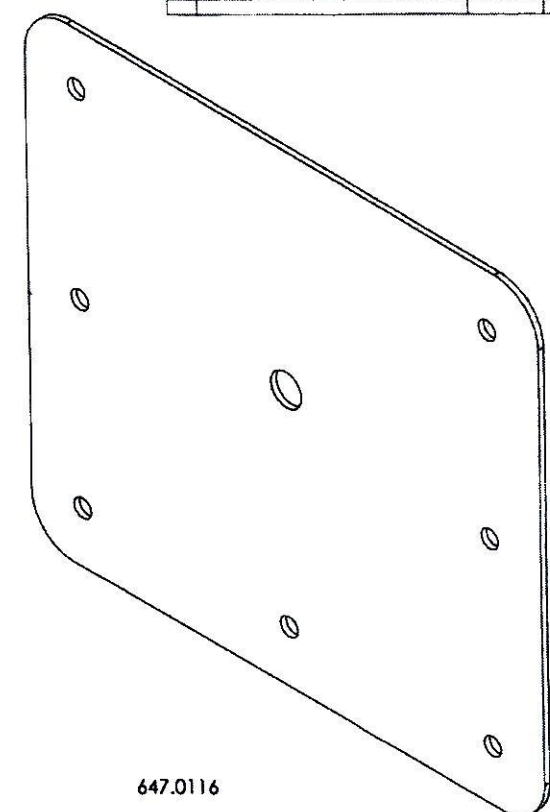
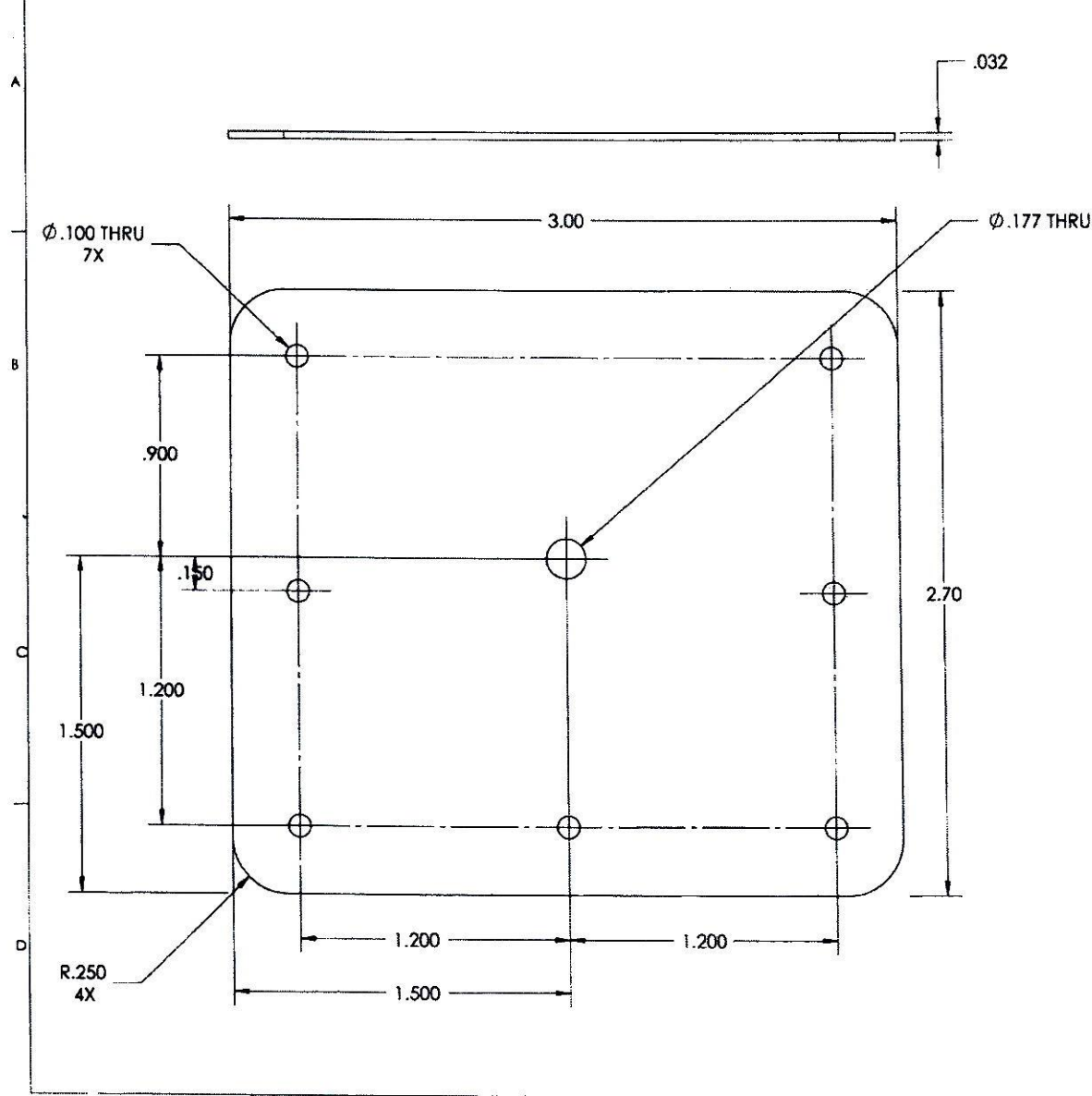
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE 10/20/24-REV. 05-28-07		APICAL INDUSTRIES	
DRAWN BY P. ROSANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY P. BRAVO		SHEETMETAL	
DRAWING APPROVAL P. BRAVO		SIZE 8	DWG NO. 647.0100
CONTRACT NO.		SCALE NONE	SHEET 5 OF 6

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



647.0116

ORIGINAL DATE 12-01-78		APICAL INDUSTRIES	
DRAWN BY: J. DOSAND P. DOSAND		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. DOSAND		SHEETMETAL	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TO FRACTIONS AND 2 PLACES DECIMALS - 01 3 PLACES DECIMALS - 000 ANGLES 1°		SHEET CODE B 07M26	REV A
		647.0100	
		SHEET 4 OF 6	